

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-015978**Date Inspected:** 25-Jul-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Gong Wai**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG COMPONENT**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Subhasis Bera was present during the times noted above for observations relative to the work being performed.

In process Inspection

Bay #14

This QA Inspector observed the following work in progress:

FCAW in the 2F position for the OBG Segment 13BE, Side plate to stiffener, weld No. SP3073-001-011~032. The welders are identified as #044795/#044790. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

FCAW in the 2F position for the OBG Segment 13BE, Side plate to stiffener, weld No. SP3073-001-088~094. The welders are identified as #044830/#044774. ZPMC QC is identified as Mr. Wang Xu. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

SMAW in the 2F position for the OBG Segment 12CW, repair weld No. SEG3006F-005. The welders are identified as #067588. ZPMC QC is identified as Mr. Wang Wai Ming. The welding variables recorded by QC appear to comply with WPS-345-SMAW-2G(2F)-REPAIR. The repair report is identified as B-CWR-1746.

SMAW in the 4F position for the OBG Segment 12AW, Deck plate to stiffener, weld No. SEG3004Z-027/028.

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The welder is identified as #067589. ZPMC QC is identified as Mr. Tang Ya Jun. The welding variables recorded by QC appear to comply with WPS-B-P-2114-FCM-1.

SMAW in the 4G position for the OBG Segment 12BW, repair weld No. SEG3005D-243. The welder is identified as #037840. ZPMC QC is identified as Mr. Tang Ya Jun. The welding variables recorded by QC appear to comply with WPS-345-SMAW-4G(4F)-FCM-REPAIR.

Out Side Segment Yard

This QA Inspector observed the following work in progress:

SMAW in the 2F position for the OBG Segment 11DW, weld No. SP745-001-300/301. The welder is identified as #045263. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-P-2112-FCW-1.

FCAW in the 2F position for the OBG Segment 11DW, weld No. SP745-001-302/303. The welder is identified as #040344. ZPMC QC is identified as Mr. Li Ping. The welding variables recorded by QC appear to comply with WPS-B-T-2132.

Magnetic Particle Testing (MPT) for lift13 Longitudinal Diaphragm

This Quality Assurance (QA) Inspector performed Visual inspection and verification of Magnetic Particle Testing (MT) 15% for OBG lift 13 longitudinal diaphragm . This QA inspector generated a (MT) report for this date .This area was previously tested and accepted by ZPMC QC MT technicians.

The Weld Designation is as follows

LD3033-001-001~005

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.



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Summary of Conversations:

No relevant conversations

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang 150-0042-2372, who represents the Office of Structural Materials for your project.

Inspected By:	Bera,Subhasis	Quality Assurance Inspector
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Reviewed By:	Patterson,Rodney	QA Reviewer
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